

Date: Tuesday, 9/4/2007 11:29:35 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DUCT
Job Number	: 34396		
Estimate Number	: 12175		
P.O. Number	: <i>N/A</i>	Part Number	: D34761
This Issue	: 9/4/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3476 REV A
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 34104	Drawing Revision	: A
		Material	: <i>N/A</i>
		Due Date	: 10/4/2007
Written By	: <i>[Signature]</i>	Qty:	6 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev: A New Issue 06-02-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.4374 sf(s)/Unit Total : 2.6246 sf(s)
304/316 0.018 SHEET
Batch: *10-05-10* *HB 07-09-06* *M105592*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
Cut as per Dwg D3476 *HB 07-09-06*
Dwg Rev: *A*
Prog Rev: *A*

(6)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 02/10/11 *(XL)*
SA 07/02/06 *(XL) counter*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1



- 1-Deburr if necessary.
- 2-Roll as per Dwg D3476
- 3-Spot weld as per Dwg D3476 and Dart QSI 018

mf *07-10-15*

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/15	5	16 pieces were scrapped under review		Scrap destroyed AND replace	07-10- 16 M.F.	G 07/10/16		G 07/10/16

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:29:35 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUCT

Job Number: 34396

Part Number: D34761

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/10/15 (1)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/15 (1)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: C-1A

MF 07-10-15 (1)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/10/17 (1)

Job Completion



LL 07-10-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

D407-667 -

203
205

WORK ORDER NON-CONFORMANCE (NCR)

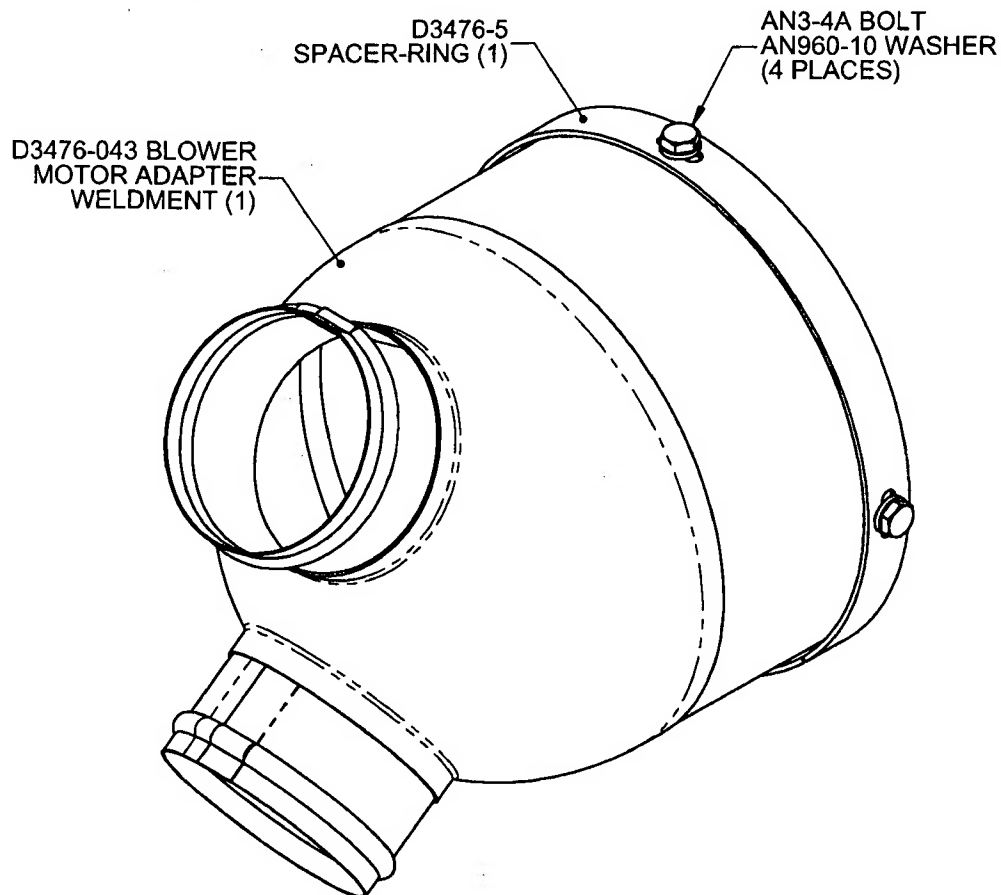
Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
	Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3476	REV. A SHEET 1 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER SCALE 1:2	
A	06.01.27	NEW ISSUE	

[Signature] 06.04.03



D3476-041 BLOWER MOTOR ADAPTER

- 1) IDENTIFY WITH DART P/N D3476-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3476-041	BLOWER MOTOR ADAPTER
1	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-5	SPACER-RING
4	AN3-4A	BOLT
4	AN960-10	WASHER

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NO. **34396**

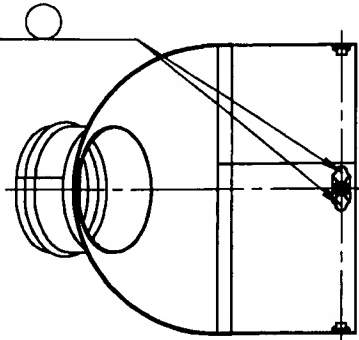
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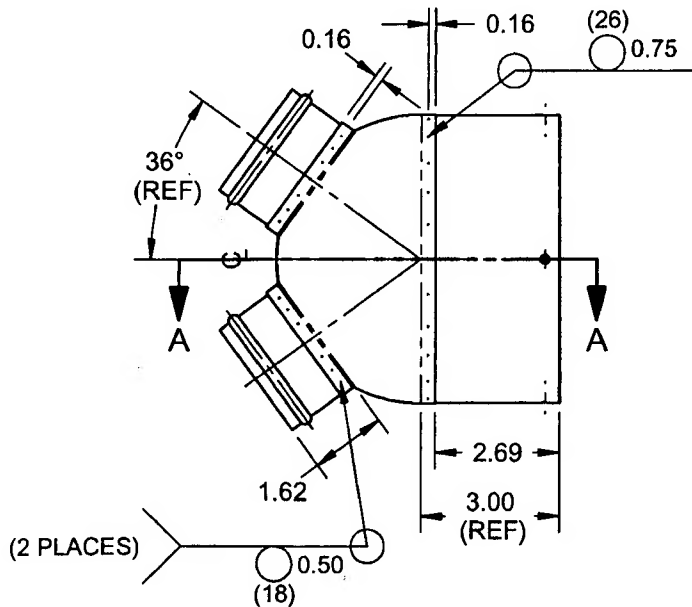
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DATE 06.01.27	TITLE BLOWER MOTOR ADAPTER		SCALE 1:4

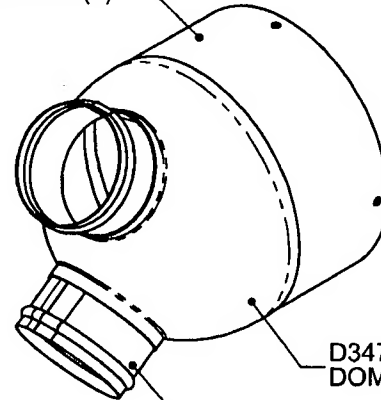
LOCATE AND
SPOT WELD
NUT PLATES
(4 PLACES)



SECTION A-A



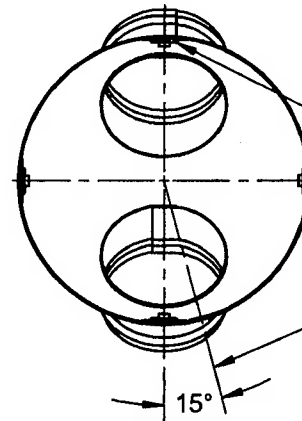
D3476-1
DUCT (1)



D3476-3
DOME (1)

D3476-7 TUBE
(2 PLACES)

NAS-1031C3W
NUT PLATES
(4 PLACES)



OFFSET SEAM
ON DUCT

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**D3476-043 BLOWER MOTOR
ADAPTER WELDMENT**

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) PART IS SYMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-1	DUCT
1	D3476-3	DOME
2	D3476-7	TUBE
4	NAS1031C3W	NUTPLATE

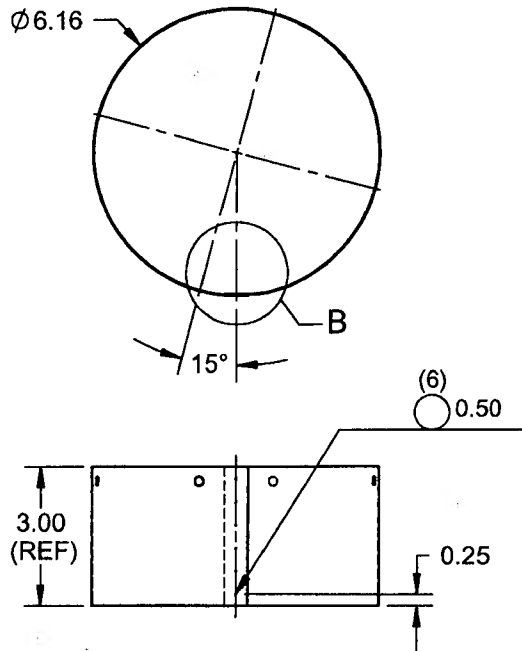
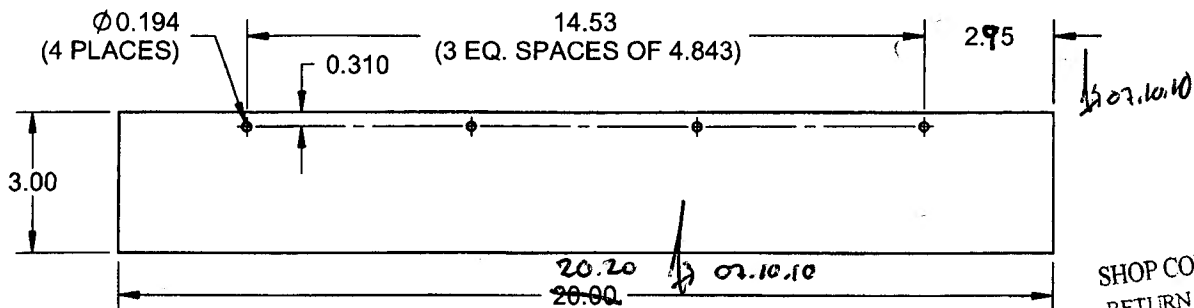
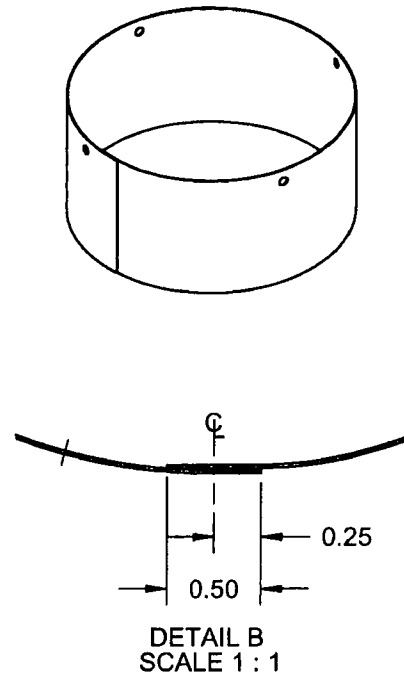
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CHECKED #	APPROVED #	DRAWING NO. D3476	REV. A SHEET 3 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:4

06.07.03

**D3476-1 DUCT****D3476-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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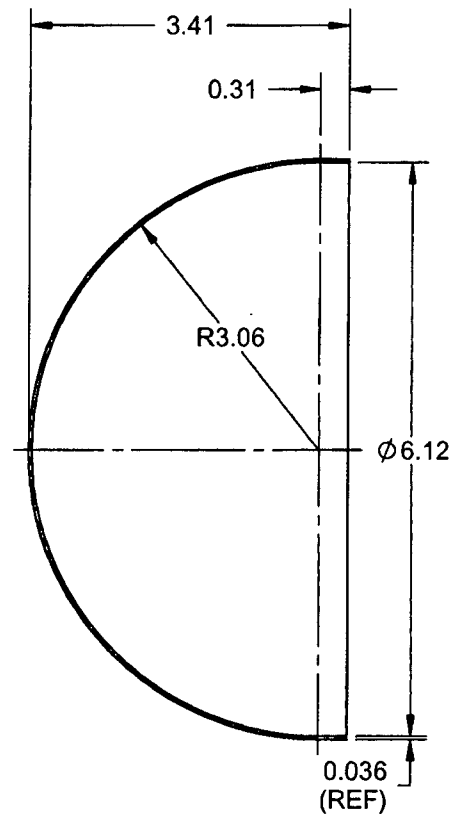
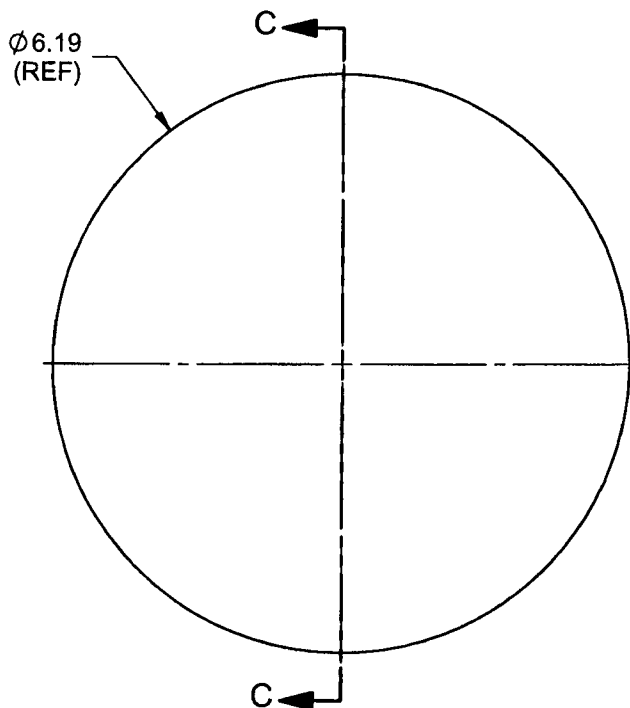
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

RELEASED

06.04.03 *[Signature]***SECTION C-C****D3476-3S DOME, SPINNING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.036 THICK PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S20GA)
- 2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING OF MATERIAL (MINIMUM THICKNESS = 0.025").
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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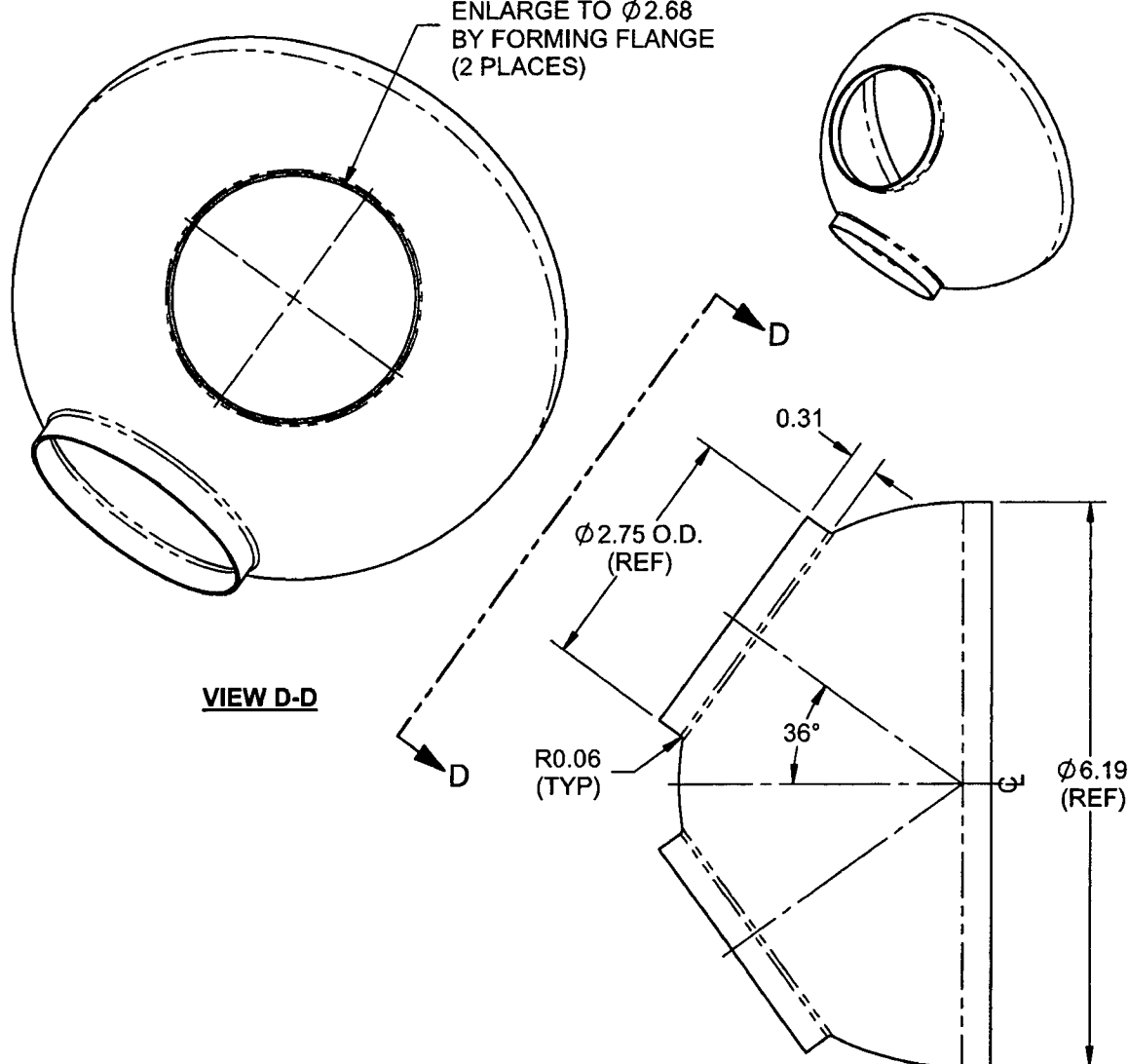
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

06.04.03

CUT $\phi 2.25$ HOLE,
ENLARGE TO $\phi 2.68$
BY FORMING FLANGE
(2 PLACES)

**VIEW D-D****D3476-3 DOME****NOTES:**

- 1) MATERIAL: MAKE FROM D3476-3S
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

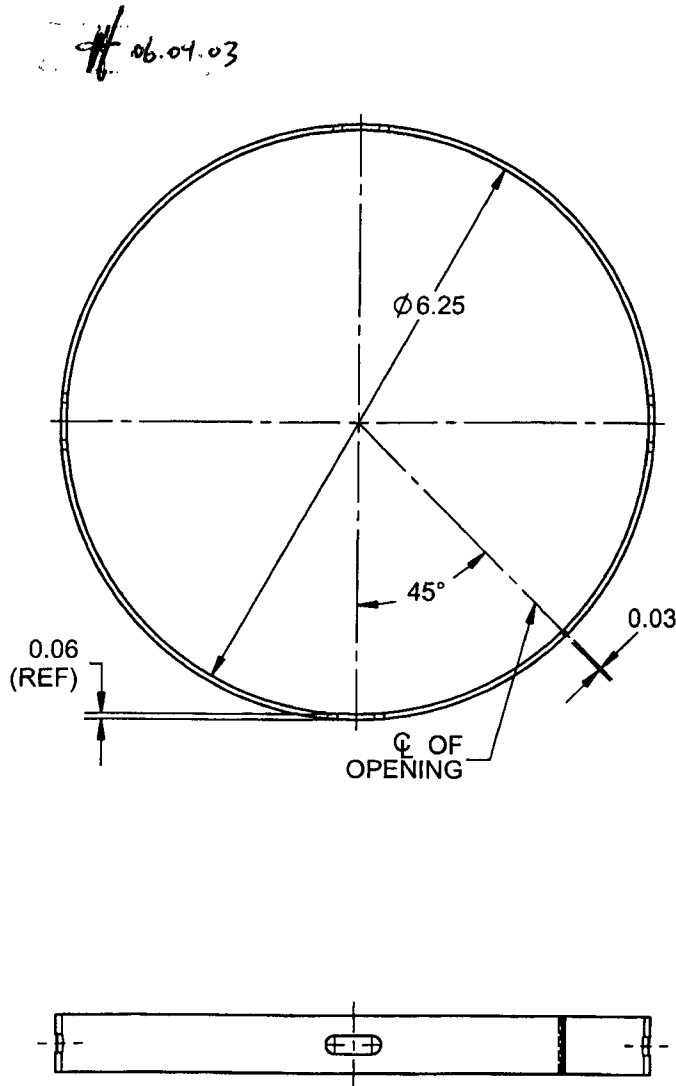
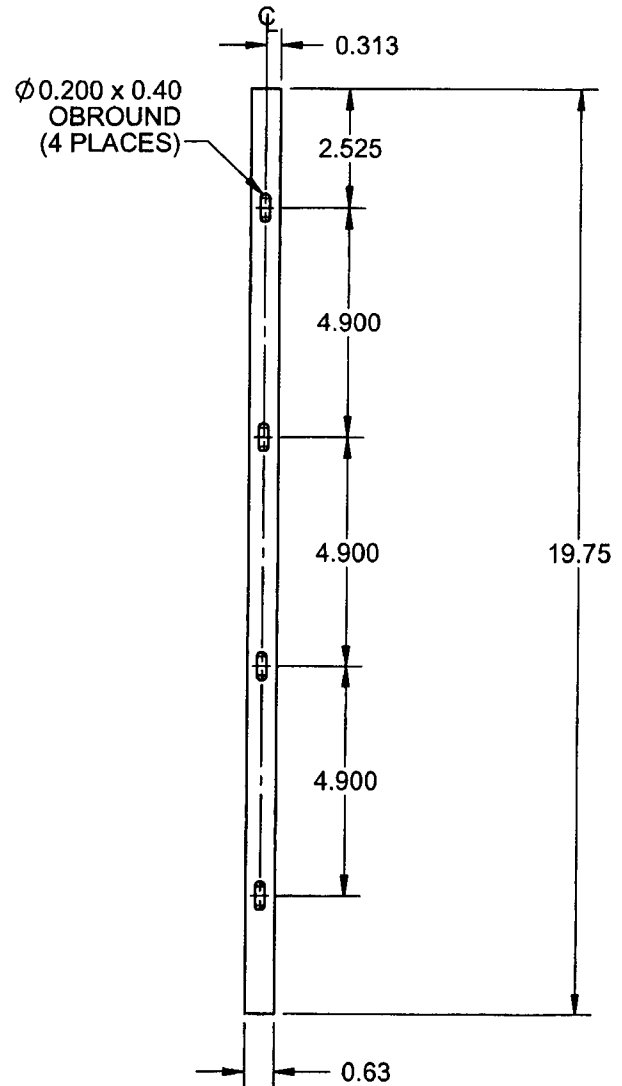
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DATE 06.01.27	TITLE BLOWER MOTOR ADAPTER		SCALE 1:2

**D3476-5 SPACER-RING****D3476-5F SPACER-RING
FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

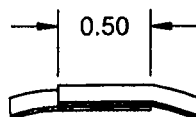
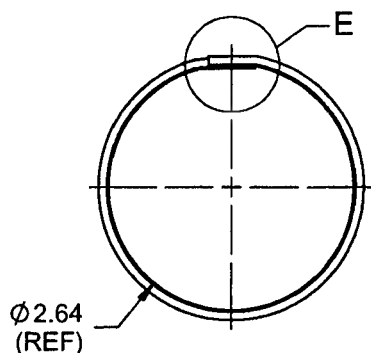
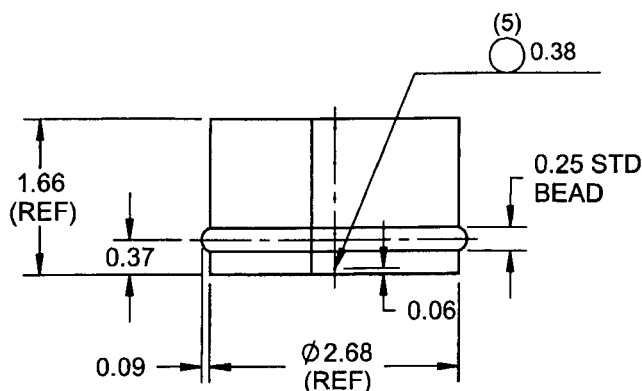
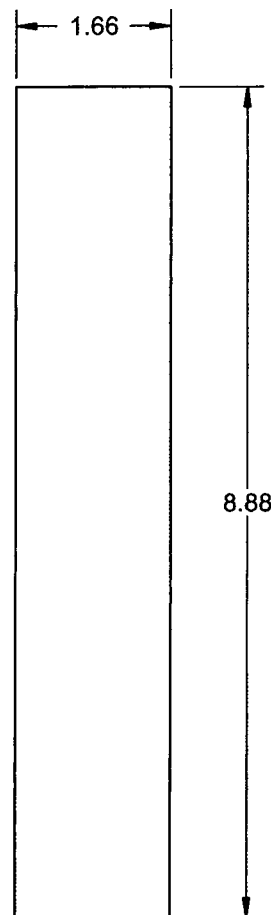
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

06.04.03DETAIL E
SCALE 1:1**D3476-7 TUBE****D3476-7 TUBE
FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order:	34396
Description: DUCT		Part Number:	D3476-1
Inspection Dwg:	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
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[illegible]

Measured by: HB	Audited by: <i>En</i>	Prototype Approval: <i>n/a</i>
Date: 07-09-06	Date: 07/09/06	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 19

EMPLOYEE: Melanie Fautant

PART NUMBER: D 3476-1

JOB NUMBER: B 34324

MATERIAL TYPE: 3.04 L

MATERIAL THICKNESS: 0.18

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium

TEST RESULTS

	PASS	FAIL
VISUAL:	[/]	[]
PENETRATION:	[/]	[]
PULL STRENGTH:	[/]	[]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/10/15

QUALIFIER: SVB

